

Work Order ID 64654

Friday, December 10, 2010 1:20:34 PM

Page 1

Item ID: D2964

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 12/13/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 10-12-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2964

Rev B

100

0.00



SHEAR

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev:

Prog Rev:

2-Deburr if necessary

10-12-13

(15)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64654

Page 2

Friday, December 10, 2010 1:20:34 PM

Item ID: D2964

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 12/13/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



8 10/12/13

(415)

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: LG

0.00



0.00

Packaging

Memo

Packaging

STOCK IN SKIDTUBE CELL

15 0 BE 10/12/13

150

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

10/12/14

WID: 12/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, December 10, 2010 1:20:34 PM

Page 1

Work Order ID: 64654



Parent Item: D2964

Parent Item Name: Cap

Start Date: 12/13/2010

Required Date: 12/20/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B□03.01.17□Reformat; Dwg revised□KJ/RF IPP REV:C
10.12.09 MADE ON WATER JET DD VERF:JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M5052H32S.080

Purchased

No

100

sf

90.3342

0.2361

2.485263

3.6



810-12-13

5052-H32 .080 Sheet

Location

Loc Qty

Loc Code

MAT22

90.3342

100682

5

100742

49.4

100947

32.9342

19729

3

100682

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

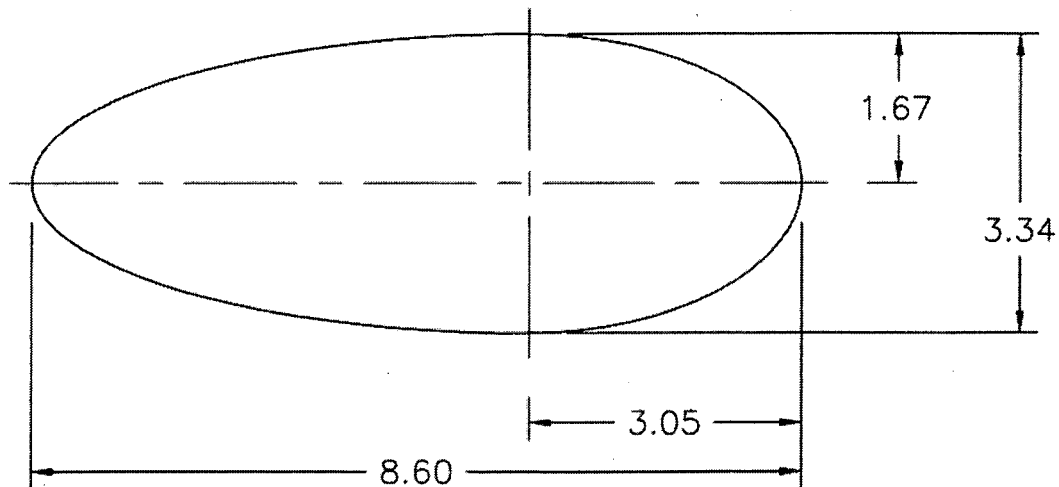
NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2964	REV. B SHEET 1 OF 1
DATE 02.12.18		TITLE CAP	SCALE 1:2
A	00.02.24	NEW ISSUE	
B	02.12.18	REDESIGN	

RELEASED
02.12.18 #

#64654



NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8), 0.080 THICK
(REF DART SPEC. M6061T6S.080 OR M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

Copyright © 2000 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries